

**ABSTRACT**

An assembly for handling and packaging pharmaceutical dosage forms includes an infeed structure, a laning structure, and a plenum structure extending from the infeed structure to the laning structure. The infeed, laning and plenum structures guide dosage forms as they are carried in a downstream direction by a surface movable with downstream direction. A guide portion guides the dosage forms into the laning structure to avoid jamming of tablets. A form handling device receives dosage forms and transports the dosage forms to a packaging device. A timed controller and dump gate operate so that debris is carried out of the assembly. The assembly is particularly useful for fragile dosage forms. A packaging device having a bottom plate with floatably supported blocks is provided for sealing dosage forms into packages.